

Work Order ID 70111

Friday, May 27, 2011 7:53:28 AM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 5/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *K*Date: *11-05-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: *M115728*

*** PLEASE NOTE ***

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
DSI9473*11-06-28*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



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Start Date: 5/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/16/28

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

H Ø M-11/26/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date:	5/27/2011	Start Qty:	1.00			
Required Date:	6/3/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 117745

2:45
3:40
3:50

IX 0 M 4 11/06/28

131



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M11786300

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: M117162

1 0 M 11/06/29

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EP 11/06/29 ①

141



Packaging

Packaging

Identify as per dwg & Stock Location: *G.A*

0.00

Memo

0.00

w/o
69766

EP 11/06/29 ①

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/29 ①

MF
11-06-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, May 27, 2011 7:53:36 AM

Page 1

Work Order ID: 70111

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly




Start Date: 5/27/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	22.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>12</div> <div></div> </div>													
<div> <div>69261</div> <div>12</div> <div></div> </div>													
<div> <div>WA006</div> <div>10</div> <div></div> </div>													
<div> <div>67465</div> <div>10</div> <div></div> </div>													
D2506  Label Plate		Manufactured	No			100	Each	10.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>10</div> <div></div> </div>													
<div> <div>69262</div> <div>10</div> <div></div> </div>													
D2512-7  Rib		Manufactured	No			100	Each	7.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA006</div> <div>7</div> <div></div> </div>													
<div> <div>65540</div> <div>3</div> <div></div> </div>													
<div> <div>67445</div> <div>4</div> <div></div> </div>													

71227

A

Pl 11.06.27

2

Pl 11.06.27

1

Pl 11.09.27

1

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

Friday, May 27, 2011 7:53:36 AM

Work Order ID: 70111

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/27/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

54.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

54

68964

26

69258

28

②

D2989-13

Manufactured No

100

Each

10.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

6

69128

2

69267

4

WA005

4

69128

4

②

D2989-19

Manufactured No

100

Each

4.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

4

69110

4

②

D3832-3

Manufactured No

100

Each

6.0000

1

1



Mesh (Lid)

Location

Loc Qty

Loc Code

WA

6

67501

3

69276

3

①

Friday, May 27, 2011 7:53:37 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 70111

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/27/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100 Each

29.0000

2

2



Mesh (Lid End)



PL 11-06-27

Location

Loc Qty

Loc Code

WA

29

64947

2

67460

27

②

D3836-041 Manufactured No

100 Each

3.0000

1

1



Rib Assembly (Basket Lid, LH)



PL 11-06-27

Location

Loc Qty

Loc Code

WA

2

69266

2

WA005

1

67447

1

①

D3836-042 Manufactured No

100 Each

3.0000

1

1



Rib Assembly (Basket Lid, RH)



PL 11-06-27

Location

Loc Qty

Loc Code

WA

3

67448

1

69271

2

①

D3852-041 Manufactured No

100 Each

3.0000

1

1



Rib Assembly



PL 11-06-27

Location

Loc Qty

Loc Code

WA

3

67449

1

69269

2

①

Friday, May 27, 2011 7:53:37 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, May 27, 2011 7:53:38 AM

Page 4

Work Order ID: 70111



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 5/27/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

4.0000

1

1



Rib Assembly



lpl 110622

Location

Loc Qty

Loc Code

WA

4

66089

1

67451

1

69268

2

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70111

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED: DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

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NOTE: Date & initial all entries

8

7

6

5

4

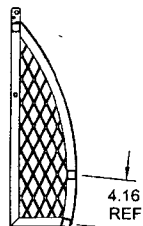
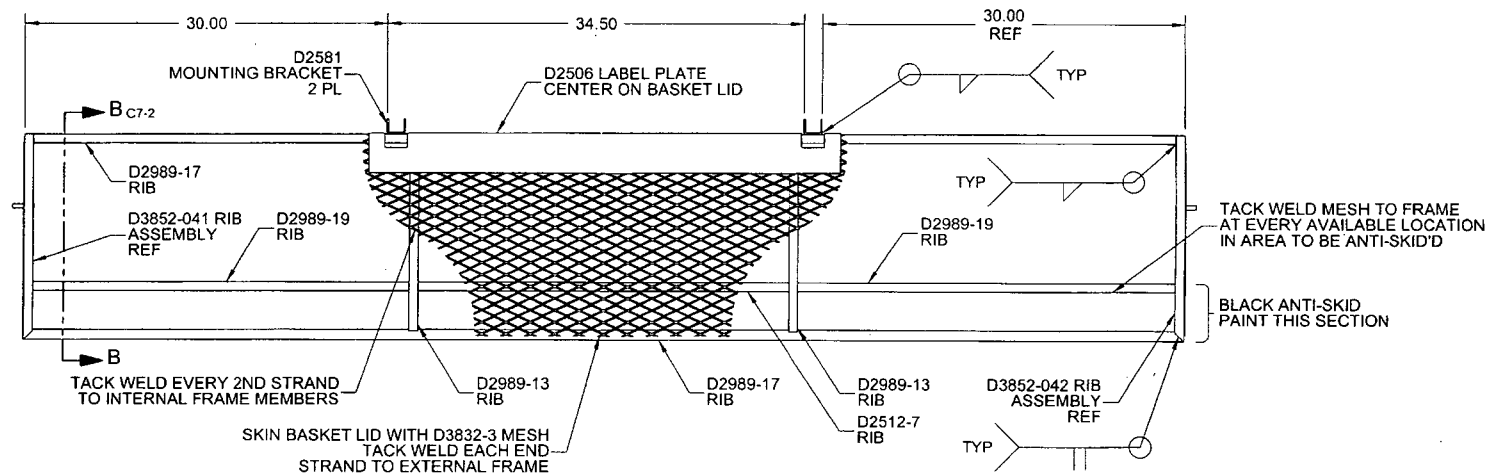
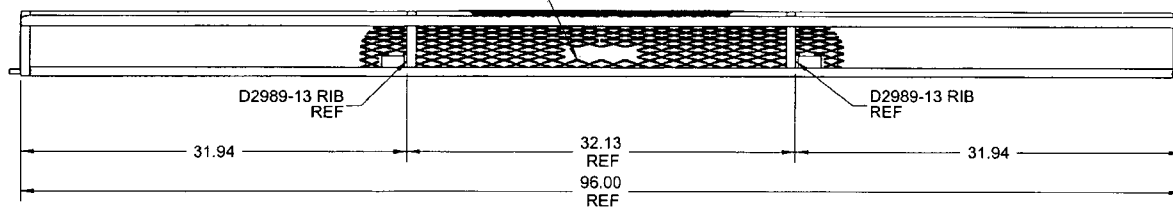
3

2

1

SECTION B-B

D7-2

4.16
REFTACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'DBLACK ANTI-SKID
PAINT THIS SECTIONTACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERSSKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAMETACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATIOND2989-13 RIB
REFD2989-13 RIB
REF

31.94

32.13
REF

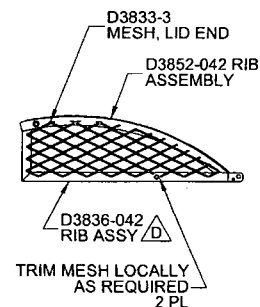
31.94

96.00
REF**D2989-041 BASKET LID ASSEMBLY**
(MESH SHOWN LOCALLY FOR CLARITY)

2 PL

FILL NOTCH
WITH WELD
9 PL**VIEW A:A** B8-2

w/o 70111

TRIM MESH LOCALLY
AS REQUIRED
2 PL**RELEASED**
08/11/12

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

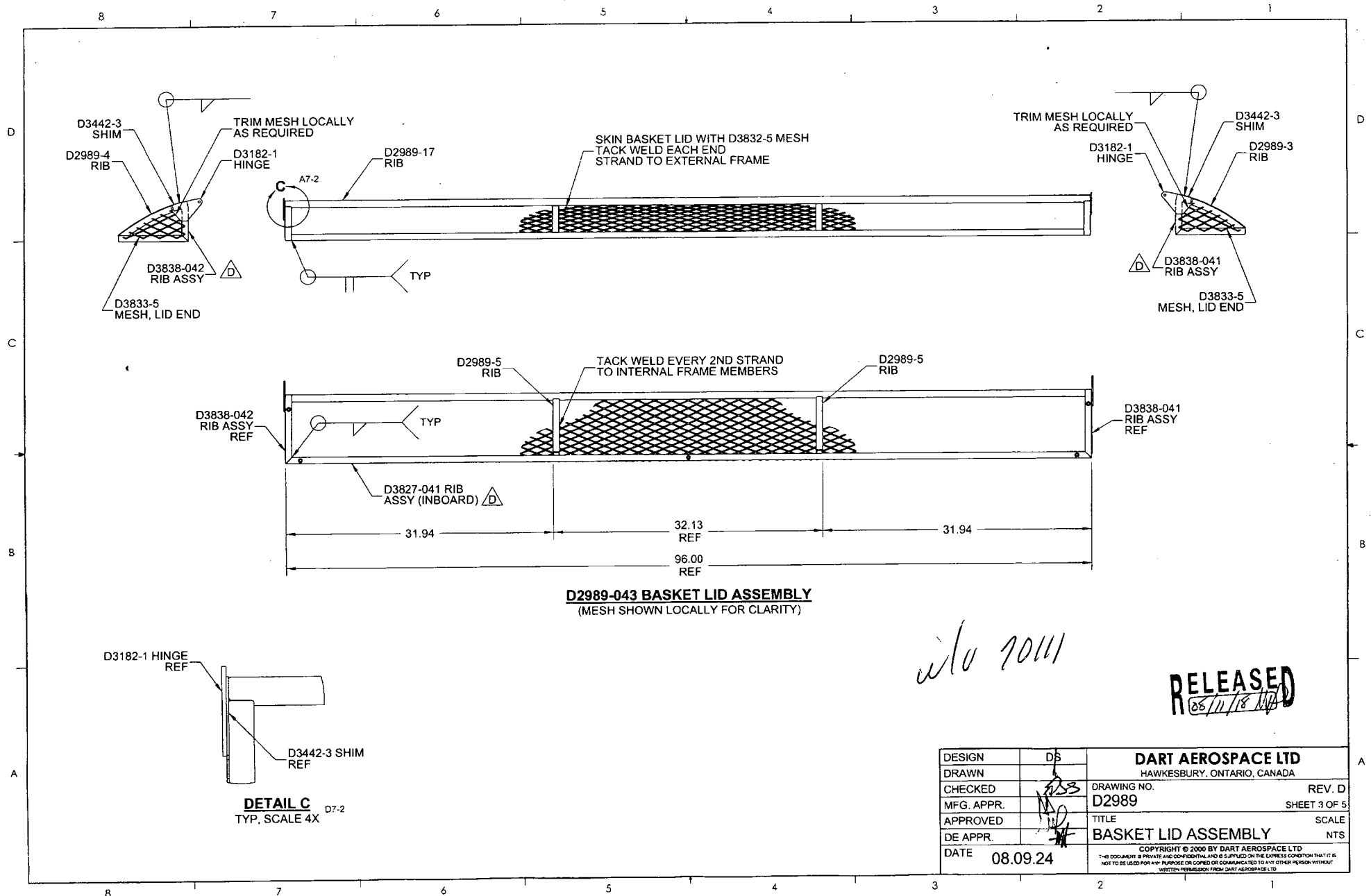
W/O:		WORK ORDER CHANGES					
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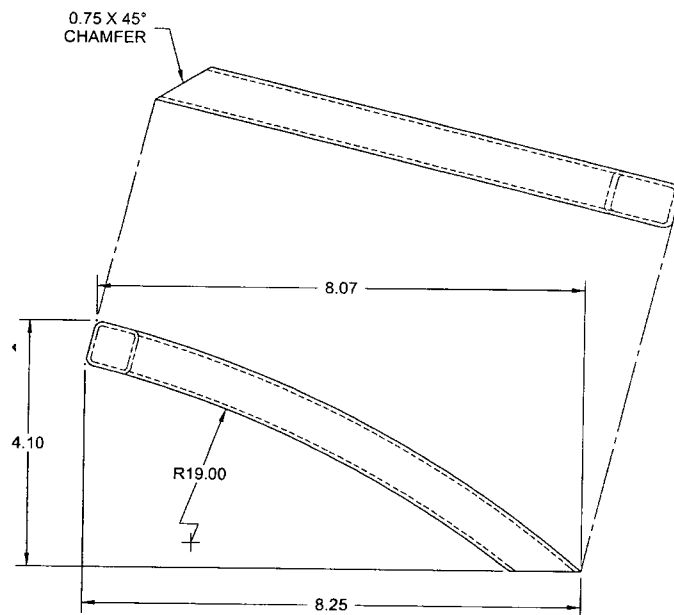
W/O:		WORK ORDER CHANGES					
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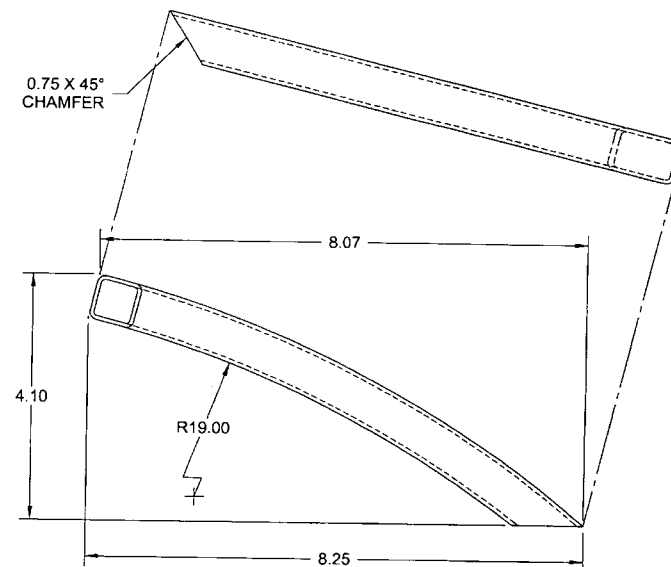
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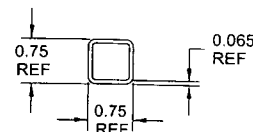
NOTE: Date & initial all entries



D2989-3 RIB





D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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RELEASED
08/11/18 NW

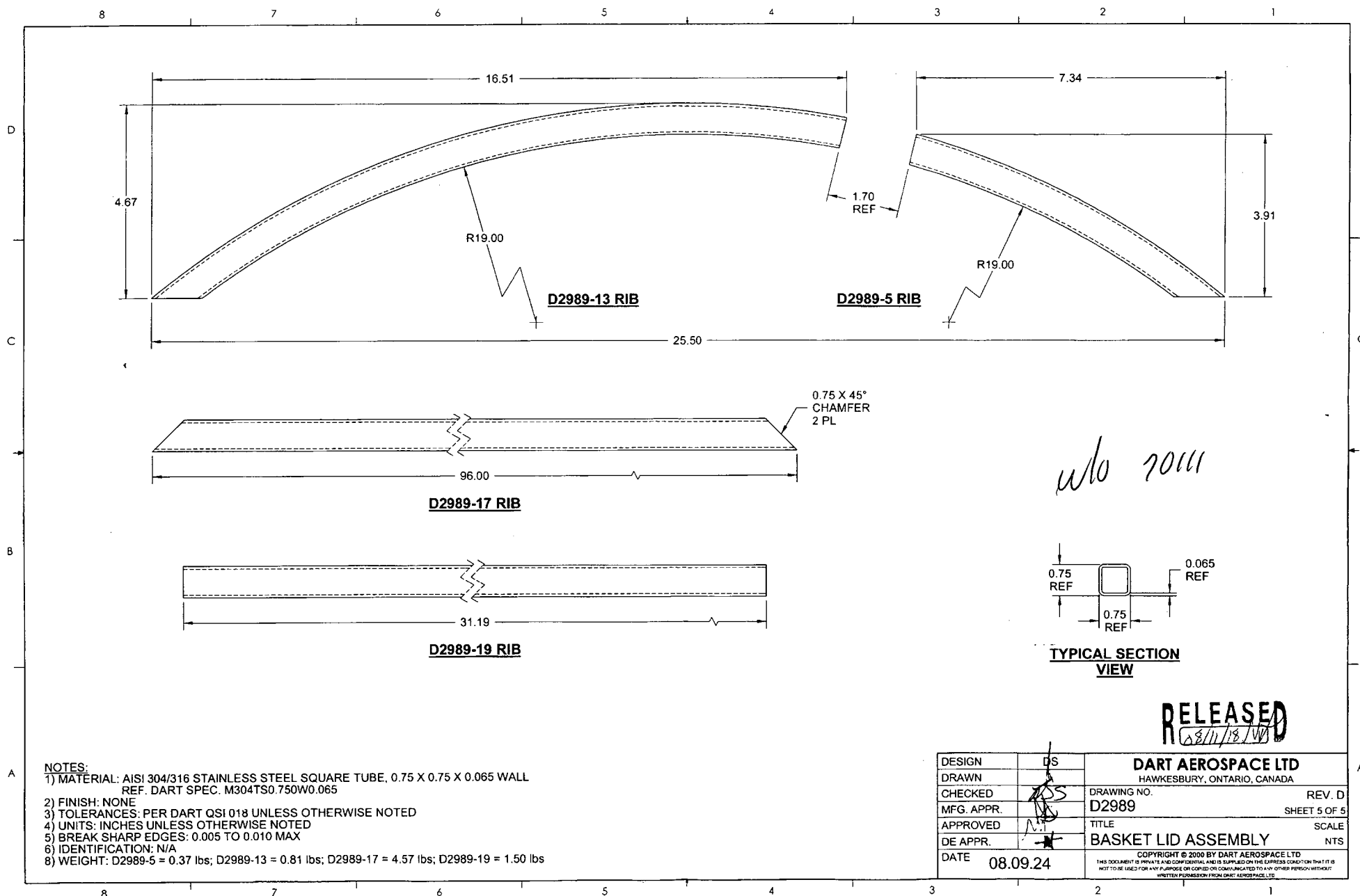
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DS	DART AEROSPACE LTD	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.	DS	SHEET 5 OF 5	
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	

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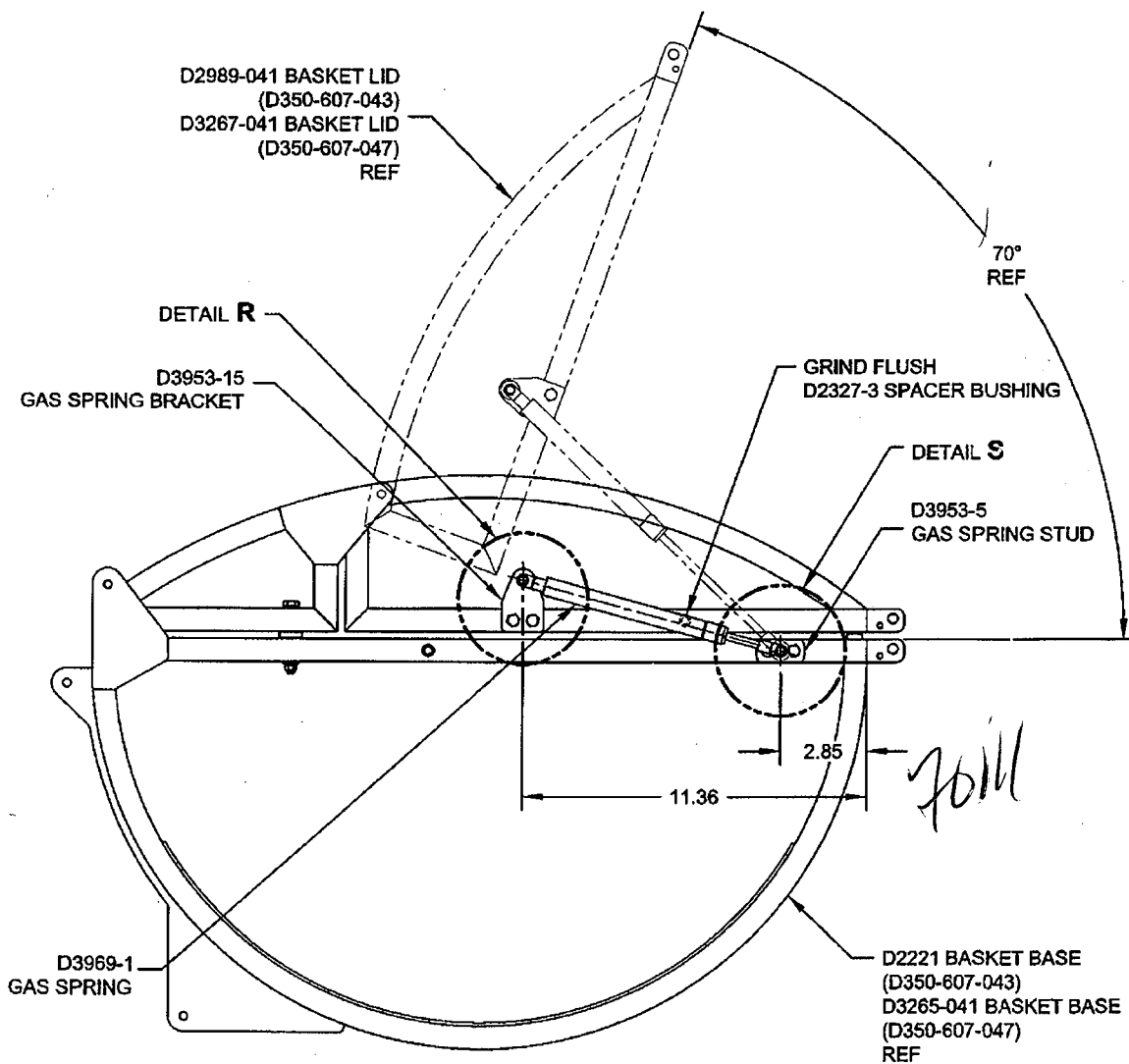
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-143 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**

Date: 10.03.10

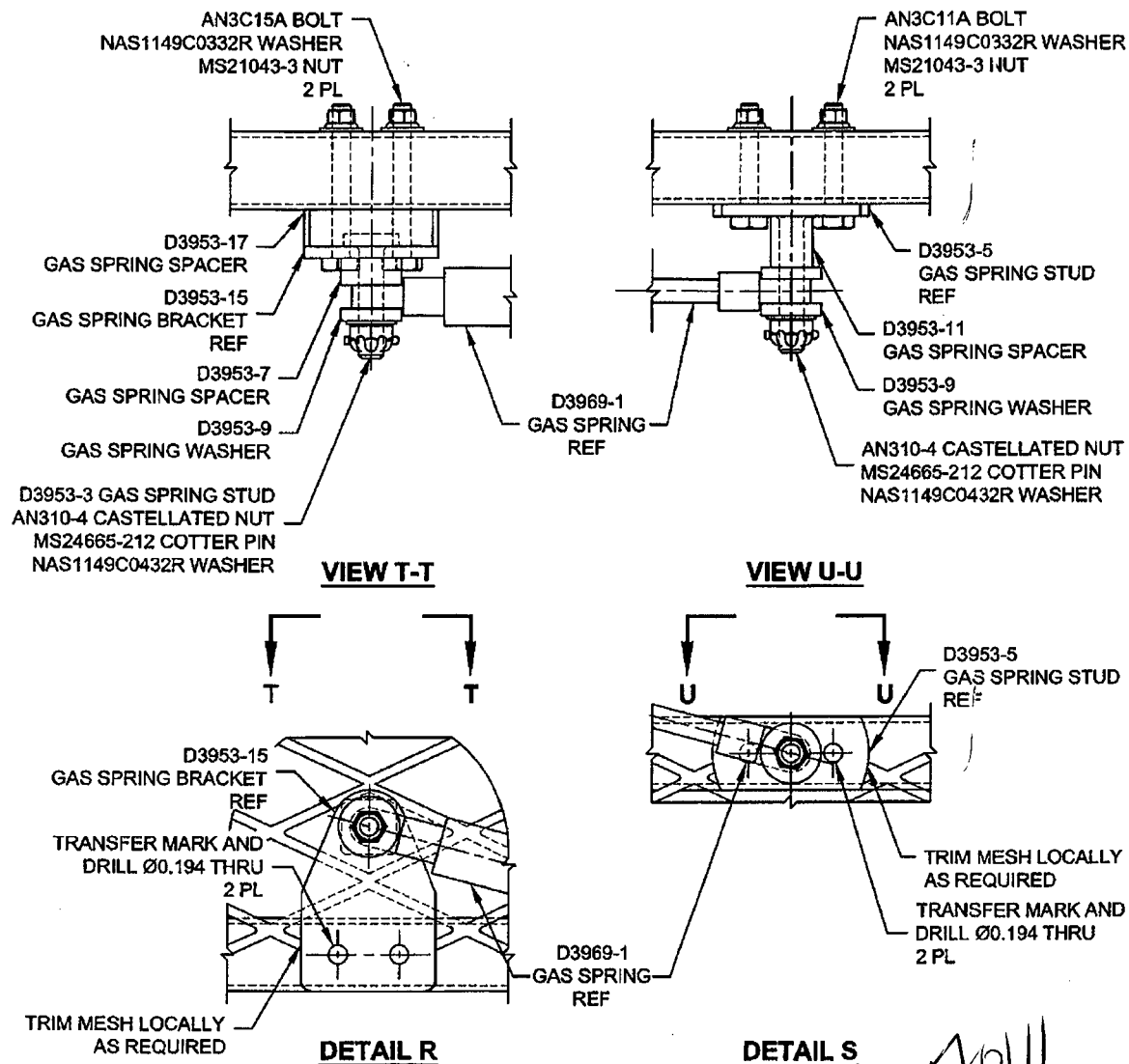


Figure 9b – Automatic Lid Opener Installation

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Revision: A

Date: 10.03.10